

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001355**Date Inspected:** 08-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Hue Wei Qing, Sha Zhi & Xu Le			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** OBG, 89 & 114 Meter Mock-Up**Summary of Items Observed:**

OBG

This Quality Assurance Inspector observed in bay 3 Zhenhua Port Machinery Company Welder Me Yu Mei, welder identification number 048625 was tack welding on weld joint SP023-01-019 & 020 between the side plate and knife plate. The essential welding variables were noted and the voltage was 28.3, the amperage 284, the travel speed 530 millimeters per minute and the preheat 25° Celsius. The Certified Welding Inspector in the bay was Wu Ming Kai.

This Quality Assurance Inspector observed in bay 3 Zhenhua Port Machinery Company Welder Sun Tiyu, welder identification 054459 welding with the flux core arc welding process on side plate SP048-01-17 & 18. The essential welding variables were noted and found the voltage to be 28.3, amperage 279, travel speed 514 millimeters per minute and the preheat 85° Celsius.

This Quality Assurance Inspector observed in bay 7 Zhenhua Port Machinery Company personnel performing back gouging of various welds on floor beam plates FB017-01-80 & FB017-02-80 SPCM.

89 Meter Mock-Up

This Quality Assurance Inspector observed in bay 2 Zhenhua Port Machinery Company Welder Zhang Feng, welder identification 049769 welding MUB-MA21 H/J 17(18) The essential welding variables observed were 23.7 for the voltage, 180 for the amperage, 137 millimeter per minute for the travel speed and 195° the preheat.

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114 Meter Mock-Up

This Quality Assurance Inspector observed in bay 2 the back gouging of MUC-MA107 B/C 2B in preparation for back welding.



Summary of Conversations:

No conversations held today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Berger,Bruce	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
